

Work Order ID 51181

August 6, 2009 1:24:38 PM



Page 1

Item ID: D3265-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Basket Base Assembly

Start Date: 8/07/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3265

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-CUT (3) D2235-1 FROM D3166-112-Drill hole in D3265-3 as per Dwg
D3265113-Remove all markings from material 14-Weld as per Dwg D3265 using
Welding Table and corner JigDebur as required

SH 09/08/17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09-08-18

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> 808/08/18

(XO) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51181

August 6, 2009 1:24:38 PM



Item ID: D3265-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Basket Base Assembly

Start Date: 8/07/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

M112260

0.00

Powder Coating

1ST COAT: START TIME: 9:00AM OVEN
TEMPERATURE: 9:30AM FINISH TIME: 400°F
2ND COAT: START TIME: 10:15AM OVEN
TEMPERATURE: 10:45AM FINISH TIME: 400°F

* pressure wash

=> 8/08/18

09-08-18 (X) (P) (S)

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(X) (P) (S)

150

Small Fab

0.00



Small Fab

Memo

Seal support gusset seam with White Sikaflex-291 Batch:
m112391 Expiry date: 10/20

mb 09/08/19

(X) (P) (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51181

August 6, 2009 1:24:38 PM



Page 3

Item ID: D3265-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Basket Base Assembly

Start Date: 8/07/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 508/04/19			④ 9			
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	PPP 51180			12/8/20		①	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	09/08/26 HJ			BP 09-8-24			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 6, 2009 1:24:37 PM

Page 1

Work Order ID: 51181

Parent Item: D3265-041RevC

Parent Item Name: Basket Base Assembly

Comments:

Start Date: 8/07/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	15.0000	2.0000			

Basket Hinge



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

50024

3

Main Warehouse

WA

12

50986

12

Manufactured No

100

Each

0.0000

2.0000

B50607 → 2x

Manufactured No

100

Each

60.0000

2.0000

Support Gusset (350 Basket)

D2327-3RevD

Spacer Bushing

Warehouse
Location

Loc Qty

Loc Code

Premier

Mezz

60

44274

51

44365

9

2x 8/4 09/08/11
8/4 09/08/11

2x 8/4 09/08/11

09/08/12

Δ 3833-1

2x

Batch: 50025

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 6, 2009 1:24:37 PM

Work Order ID: 51181

Parent Item: D3265-041RevC

Parent Item Name: Basket Base Assembly


Comments:

Start Date: 8/07/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	49.0000	2.0000			
												
Mounting Bracket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5

46086 2

48428 3

Main Warehouse

WA 44

50872 44

A2235-1

D3166-1RevA1

Manufactured No

100 Each

11.0000

3.0000



B 50822 → 1x

Basket Hoop

2x SY 09/08/11

SY 09/08/11

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 11

50570 1

50941 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 6, 2009 1:24:37 PM

Work Order ID: 51181

Parent Item: D3265-041RevC

Parent Item Name: Basket Base Assembly


Comments:

Start Date: 8/07/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-5RevA		Manufactured	No			100	Each	70.0000	2.0000			
												
Shim												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 70

33282 70

M304EX0.75-16F

Purchased

No

100 sf

736.7735 26.0000



Expanded Metal Flat SS

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 736.7735065

108152 90

110134 6.7

110292 14.4

110629 14.41

110861 21.18

110992 0.58

111444 4.14

111630 9.15

111956 6.335517

112147 121.877989

112311 448

2x SH 09/08/11
SAD 09-08-11

26.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

August 6, 2009 1:24:37 PM

Work Order ID: 51181

Parent Item: D3265-041RevC

Parent Item Name: Basket Base Assembly

Comments:

Start Date: 8/07/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	668.8315	19.2632			



304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

68.83151369

111148

0.484

111432

0.44

111885

1.5682

112051

7.3691E-05

112263

66.33924

Main Warehouse

WA

600

112344

600

~~2.125~~ 3.1382
JY 09/08/11
16.125

August 6, 2009 1:24:37 PM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
2	D2232-3	HINGE PLATE
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D2327-3	BUSHING
2	D2581	MOUNTING BRACKET
2	D3265-1	RIB
2	D3265-3	RIB
2	D3265-5	RIB
2	D3442-5	SHIM

all
51181

DEO ATTACHED

RELEASED
08-09-01/11/12

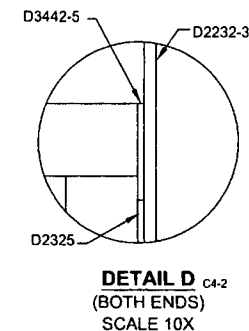
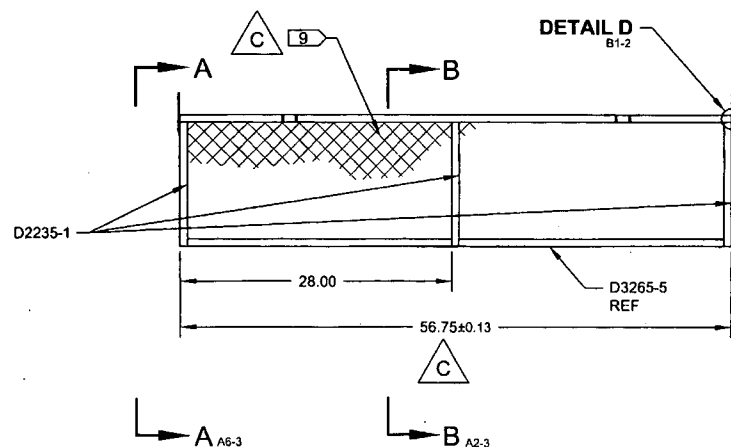
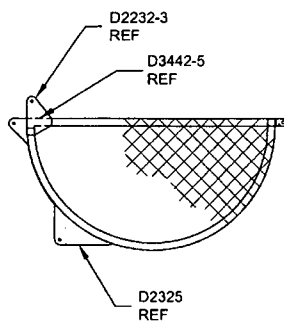
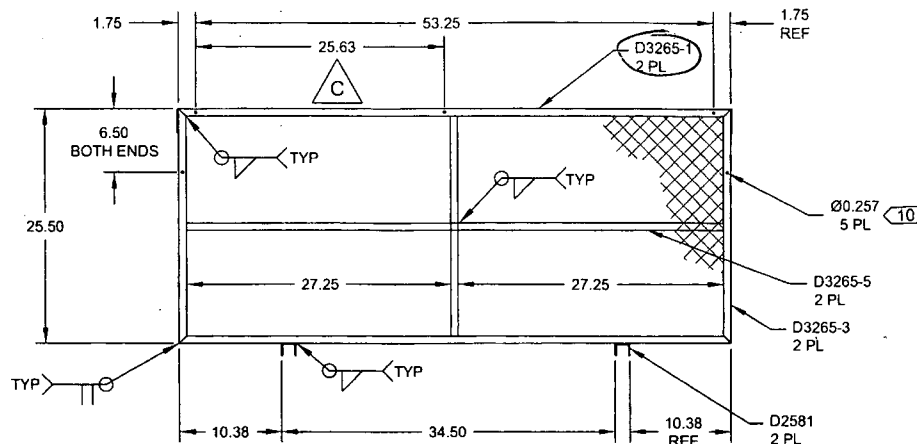


NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3265	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



BASE ASSEMBLY NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH EXPANDED STEEL MESH. TACK WELD EACH END OF STRAND TO FRAME.
- 10) DRILL WHEN ASSEMBLING WITH D3267-041/-043 LID ONLY.

D3265-041 BASKET BASE ASSEMBLY

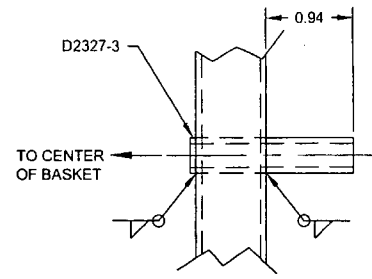
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3265	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

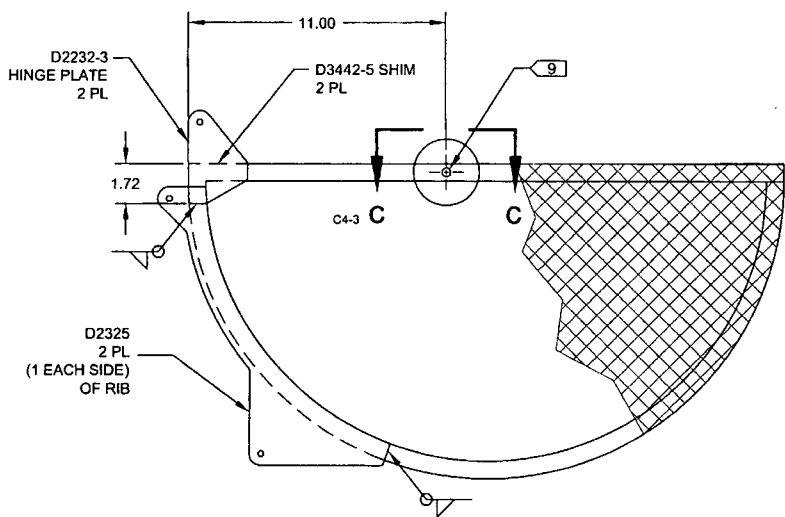
51181

DEO ATTACHED
 RELEASED
 08.09.14

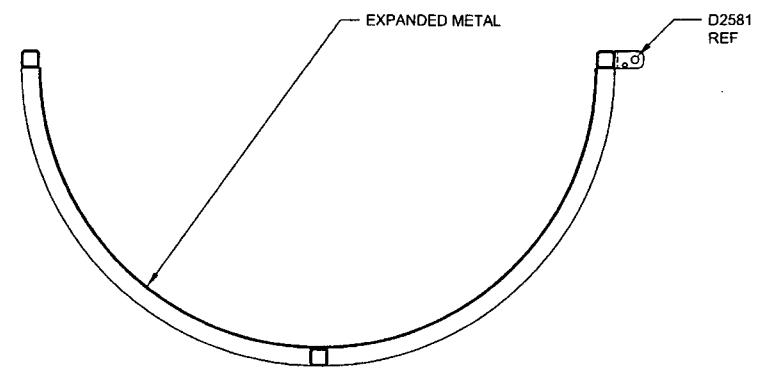
8 7 6 5 4 3 2 1



VIEW C-C B7-3
2 PL
SCALE 4X
ROTATED 90° CCW



SECTION A-A A5-2
2 PL
(BOTH END RIBS)



SECTION B-B A4-2
2 PL
(BOTH CENTER RIBS)

NOT ATTACHED
RELEASED
08-04-11

- NOTES:**
- 1) MATERIAL: SEE SHEET 1
 - 2) FINISH: SEE SHEET 1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELD PER DART QSI 004
 - 9) DRILL 3/8 HOLE AND INSTALL D2327-3 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	SA	DRAWING NO.	REV. C
MFG. APPR.	SA	D3265	SHEET 3 OF 4
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3265-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>PH</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09.04.16	DATE 09.04.16		DATE 09.04.16		

SHEET 1, MODIFY PARTS LIST AS FOLLOWS:

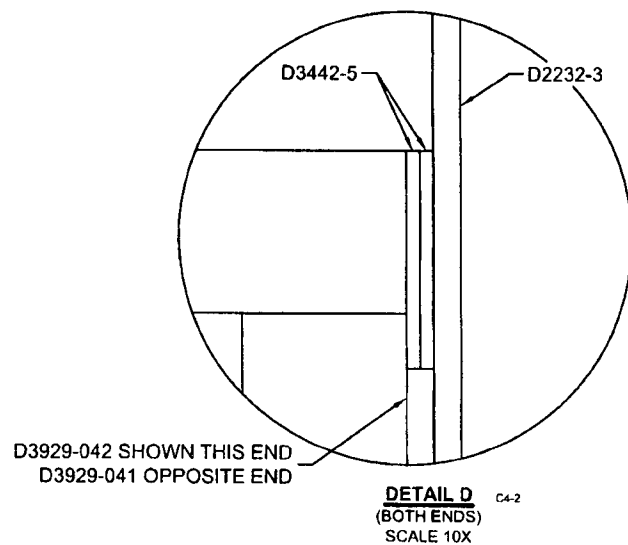
IS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
3	D2235-1	RIB
2	D3929-041	GUSSET ASSEMBLY
2	D3929-042	GUSSET ASSEMBLY
4	D3442-5	SHIM

WAS:

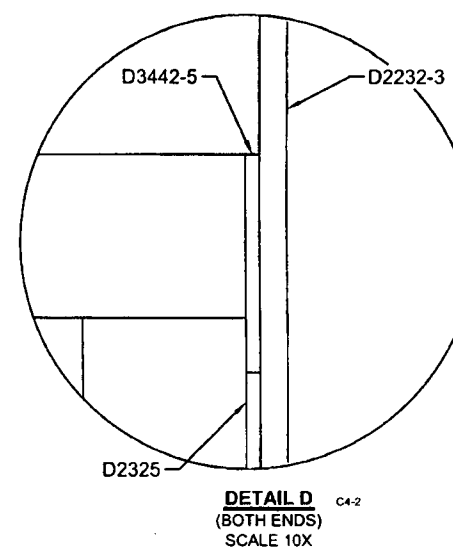
QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D3442-5	SHIM

SHEET 2, MODIFY DETAIL D AS SHOWN:



51181

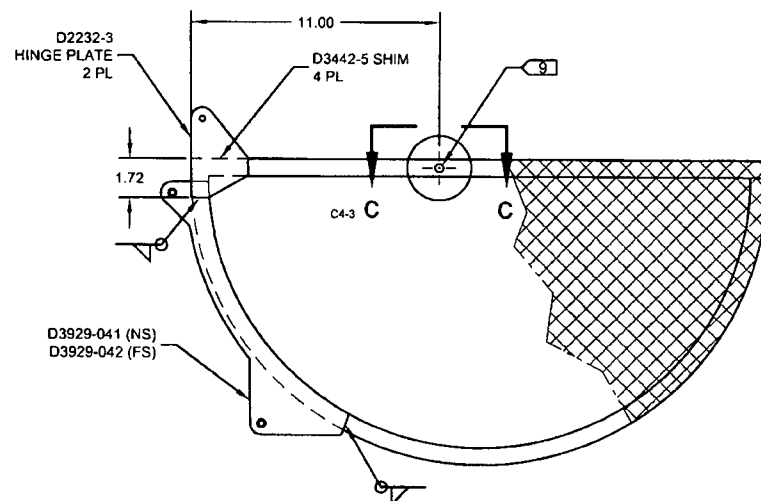
RELEASED
21/04/22



DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3265-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>LB</i>	CHECKED <i>PH</i>	MFG. APPR. <i>AD</i>	APPROVED <i>PH</i>	DE APPR. <i>PH</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09/04/17	DATE 09.04.17	DATE 09.04.17		

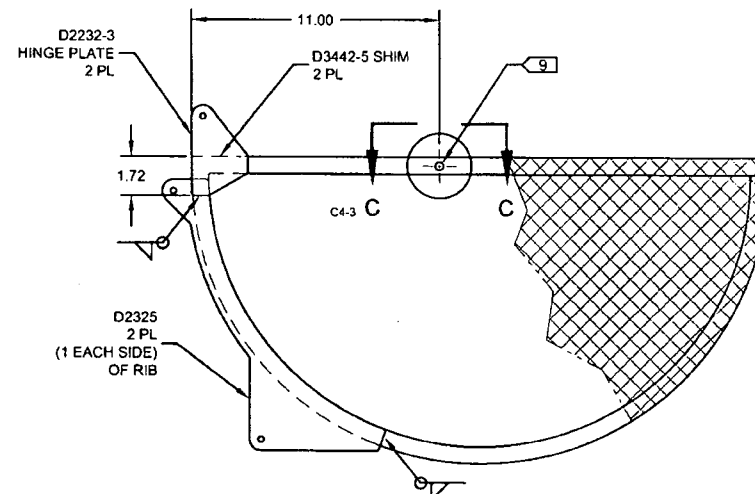
SHEET 3, MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

WAS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

RELEASED
09/04/17

51181